

Work Order ID 164628

Tuesday, July 25, 2017 1:32:13 PM

164628

Page 1

Item ID: D2573

Revision ID:

Item Name: Saddle, Aft, Out

Start Date: 7/25/2017 Start Qty: 4.00

Required Date: 8/4/2017 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: **DAS 21** **JUL 25 2017** Date: _____

QC: _____ Date: _____

Tooling: _____

SPC (Y/N): _____

Date: _____

Date: _____

N900040100

Cust Item ID:

Customer:

Setup Start ***NS1***

Stop ***NS2***

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2573	F								

100

2.21

100

HAAS I

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Program Batch No. **164628**

Double check by **mmL**

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

DAS

44

9-89

17-07-29

110

0.00

110

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

Machine keyway as per dwg D2573 & D2574

0.36

DAS

44

9-89

17-07-29

Tuesday, July 25, 2017 1:32:13 PM

Page 2

JSU
BE 13

Work Order ID 164628

164628

Page 3

Tuesday, July 25, 2017 1:32:13 PM

Item ID: D2573 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle, Aft, Out
 Start Date: 7/25/2017 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 8/4/2017 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M BGAH</i> Memo START TIME: <i>2:25</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>2:55</i>	0.00 0.08				<i>6</i>	<i>0</i>	<i>17.08.2</i>	<i>25 8 0</i>
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.04				<i>6</i>			<i>DAS 38 9-89</i> <i>AUG 03 2017</i>
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <i>57398</i> Memo	0.00 0.04				<i>6</i>		<i>AUG 04 2017</i>	<i>rf</i> <i>DAS 26 9-89</i>

Work Order ID 164628

Tuesday, July 25, 2017 1:32:13 PM

164628

Page 4

Item ID: D2573

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Aft, Out

Start Date: 7/25/2017 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 8/4/2017 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.40

Quality Control

17/8/9 48



AUG 04 2017

Picklist Print

Tuesday, July 25, 2017 1:32:17 PM

Page 1

Work Order ID: 164628

164628

Parent Item: D2573

D2573

Parent Item Name: Saddle, Aft, Out

Start Date: 7/25/2017

Required Date: 8/4/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	18.0000	1	4			
D6101-007									**				
Saddle Billet													

DAS
44
9-89 17-07-29

Location

Loc Qty

Loc Code

MAT041

18

159705

18

4

DART AEROSPACE LTD	Work Order: 164628
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.003	8.002	8.001		
F	0.490	0.510		.497	.501	.501	.500		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.503	.503	.503	.503		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.570	.570	.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.130	.130	.130	.130		
Q	0.115	0.135		.126	.126	.127	.126		
R	0.240	0.260		.253	.253	.254	.253		
S	0.115	0.135		.125	.125	.127	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.240	.241	.241	.241		
W	0.115	0.135		.122	.126	.126	.125		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.366	.366	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.629	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.252	.252	.252		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.270	.270	.270	.270		
AH	0.240	0.260		.249	.250	.251	.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: 44	Audited by: DAS
Date: 17-07-20	Date: 49 17/08/01
	9-89

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order:	
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. F	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	3	4		
A	0.438	0.443		.438	.439				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.002	8.002				
F	0.490	0.510		.502	.501				
G	0.257	0.262		.257	.257				
H	0.375	0.380		.375	.375				
I	0.490	0.510		.502	.503				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.569	.569				
L	1.174	1.184		1.179	1.179				
M	1.365	1.375		1.370	1.370				
N	2.495	2.505		2.500	2.500				
O	4.119	4.129		4.124	4.124				
P	0.115	0.135		.130	.130				
Q	0.115	0.135		.126	.127				
R	0.240	0.260		.253	.254				
S	0.115	0.135		.125	.125				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.230	3.230				
V	0.230	0.250		.242	.240				
W	0.115	0.135		.124	.125				
X	0.308	0.313		.311	.311				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.365	.364				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.625	.625				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.253	.252				
AE	1.500	1.520		1.510	1.510				
AF	0.115	0.135		.125	.125				
AG	0.240	0.280		.270	.270				
AH	0.240	0.260		.251	.250				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by: 9-69	Audited by: DAS 49
Date: 17-07-31	Date: 17/08/01

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

